



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-311
Job Sheet 171528



Part No: D350-591-311

Job Qty: 1 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 2/2/18

Job Tracking No:

Due Date: 2/9/18

Created By: Jason Leroux

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in born DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	2/8/18	2/8/18	0.00	0.00	Start Up Large Fab-4		SL 2/5/18
110	Large Fab	1 pcs	2/8/18	2/8/18	0.00	0.99	Large Fab 2		SL 2/6/18
120	QC	1 pcs	2/8/18	2/8/18	0.00	0.00	QC9		CPC
130	QC	1 pcs	2/8/18	2/8/18	0.00	0.00	QC5		CPC
140	HandFinish	1 pcs	2/8/18	2/8/18	0.00	0.18	HandFinish1		18-02-06 JPL
150	QC	1 pcs	2/8/18	2/8/18	0.00	0.00	QC7-2		CPC
180	Large Fab	1 pcs	2/8/18	2/8/18	0.00	0.99	Large Fab 2		SL
190	QC	1 pcs	2/8/18	2/8/18	0.00	0.00	QC10		CPC
200	QC	1 pcs	2/8/18	2/8/18	0.00	0.00	QC5		CPC
210	HandFinish	1 pcs	2/8/18	2/8/18	0.00	0.18	HandFinish1		18-02-13 JPL
220	Powdercoat	1 pcs	2/8/18	2/8/18	0.00	0.29	Powdercoat1		BR 18-2-21
230	HandFinish	1 pcs	2/9/18	2/9/18	0.00	0.18	HandFinish3		BEB 18-02-21
240	QC	1 pcs	2/9/18	2/9/18	0.00	0.00	QC3		FEB 27 2018
250	Packaging	1 pcs	2/9/18	2/9/18	0.00	0.00	Packaging1-3		SL
260	QC	1 pcs	2/9/18	2/9/18	0.00	0.00	QC4		SimB
265	DC	1 pcs	2/9/18	2/9/18	0.00	0.00	DC		SimB
270	Packaging	1 pcs	2/9/18	2/9/18	0.00	0.00	Packaging3-1		SimB
280	QC21-FG	1 Ea	2/9/18	2/9/18	0.00	0.00	QC21		21 FEB 27 2018

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod 138673 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 138673 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 9:20 OVEN TEMPERATURE: 300° FINISH TIME: 9:50

265 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

wing walk M138761

000 713

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	1 Ea (1 ea)	90-Start up Operation	
D3219-1	Plate	2 Ea (2 ea)	90-Start up Operation	
D3272-1	Step	1 Ea (1 ea)	90-Start up Operation	
D3065-041	Step Leg Assembly	1 Ea (1 ea)	180-Large Fab	
D3066-1	Spacer	2 Ea (2 ea)	180-Large Fab	
D3067-1	End Plate	1 Ea (1 ea)	180-Large Fab	
MS20600-AD4W4	Rivet	16 Ea (16 ea)	180-Large Fab	
AN3-35A	Bolt	2 Ea (2 ea)	250-Packaging	
AN4-13A	Bolt	8 Ea (8 ea)	250-Packaging	
AN5-36A	Bolt	2 Ea (2 ea)	250-Packaging	
D2230-3	Mounting Lug	4 Ea (4 ea)	250-Packaging	
D2618	Bushing	2 Ea (2 ea)	250-Packaging	
D2856-400-720	Abrasion Strip 4" X 7.20"	2 Ea (2 ea)	250-Packaging	
D3235-1	Mounting Lug	2 Ea (2 ea)	250-Packaging	
D3278-041	Support Assembly	1 Ea (1 ea)	250-Packaging	
MS21042L3	Nut	2 Ea (2 ea)	250-Packaging	
MS21042L4	Nut	8 Ea (8 ea)	250-Packaging	
MS21042L5	Nut	2 Ea (2 ea)	250-Packaging	
NAS1149D0363J	Washer	4 Ea (4 ea)	250-Packaging	
NAS1149D0463J	Washer	16 Ea (16 ea)	250-Packaging	
NAS1149D0563J	Washer	4 Ea (4 ea)	250-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	1	101	0
	D3219-1	2	106	0
	D3272-1	1	0	0
180-Large Fab	D3065-041	1	2	0
	D3066-1	2	90	0
	D3067-1	1	101	0
	MS20600-AD4W4	16	1,321	0
	AN3-35A	2	182	0
250-Packaging	AN4-13A	8	690	0
	AN5-36A	2	108	0
	D2230-3	4	169	0
	D2618	2	58	0
	D2856-400-720	2	163	0
	D3235-1	2	43	0
	D3278-041	1	30	0
	MS21042L3	2	2,133	0
	MS21042L4	8	2,249	0
	MS21042L5	2	537	0
	NAS1149D0363J	4	3,781	0
	NAS1149D0463J	16	3,660	0
	NAS1149D0563J	4	873	0

Part Specifications

Specifications could not be found.

Plex 2/2/18 11:55 AM dart.leroux.jason



S038936



Dart Aerospace Ltd.

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CANADA

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Heli - Access - Step LH - High Gear, Long Step, Aerazur
Float Compatible

PART NO: D350 - 591 - 311

Original Serial #: S038936

Revision:

Operation:

Change No:

Start up Operation

CHG002

02/05/18

Job No: 171528



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Master Unit 000713

Containers on Master Unit 000713				
Serial No	Part No	Customer Part No	Status	Quantity
S044340	AN3-35A		Allocated	2
S044339	AN4-13A	AN4-13A	Allocated	8
S044338	AN5-36A	AN5-36A	Allocated	2
S044337	D2230-3	D2230-3	Allocated	4
S044336	D2618	D2618	Allocated	2
S044335	D2856-400-720	D2856-400-720	Allocated	2
S040919	D3065-041	D3065-041	Allocated	0
S040920	D3066-1	D3066-1	Allocated	0
S040921	D3067-1		Allocated	0
S044334	D3278-041	D3278-041	Allocated	1
S044343	MS21042L3	MS21042L3	Allocated	2
S044332	MS21042L4	MS21042L4	Allocated	8
S044331	MS21042L5	MS21042L5	Allocated	2
S044330	NAS1149D0363J	NAS1149D0363J	Allocated	4
S044328	NAS1149D0463J	NAS1149D0463J	Allocated	16
S044327	NAS1149D0563J	NAS1149D0563J	Allocated	4

QC-1 D2230-3 S044336

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Hel-Access-Step™</i> , Short Step – High Skid, LH
	X					D350-591-214	<i>Hel-Access-Step™</i> , Short Step – High Skid, RH
		X				D350-591-215	<i>Hel-Access-Step™</i> , Short Step – Low Skid, LH
			X			D350-591-216	<i>Hel-Access-Step™</i> , Short Step – Low Skid, RH
				X		D350-591-311	<i>Hel-Access-Step™</i> , Long Step – High Skid, LH
					X	D350-591-312	<i>Hel-Access-Step™</i> , Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

Change Record

PAGE 1 OF 1

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

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